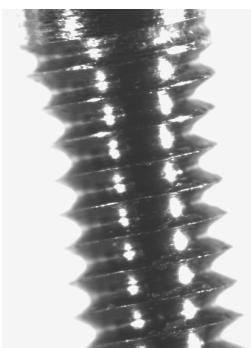


## Tap former M1.2 Z4

A10-150

The NGM Tap machine is equipped with 2 grinding spindles, 2 dressing units, an oscillating table (W-axis) and a 6-axis robot. In the production cycle the dressing cycles are included. The dressing of the slot needs only being done some few time.



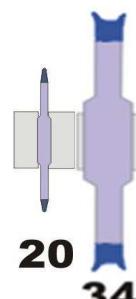
### 1. Cycletime for Production

Tool specifications M1.2, Length 4 mm Material HSS					
Operations	Thread	Tip cutting	Chamfer	dressing	dress slot
Feed [mm/Min]	7000	15000	7500	36	36
Power [kW]	3	2	2	1	1
Cutting feed [m/s]	55	55	55	14	14
Used wheels	37	37	37	34	20
Grinding time [s]	61	33	20	39	14
Total cycle time	2 Min 33				

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

37 Ø400 1A1 A230  
20 Ø125 14EE1 D301  
34 Ø125 NCC 2xR0.3 D301



### 3. Machine and Software Requirements

Machines: 6 axes CNC grinders : NGM TAP, dressing unit  
Control: Fanuc 31i B5  
Coolant: Synthetic Oil  
Software: Quinto 5.4.6

responsible engineer: FFR,24.04.14

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